



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9701
Job Sheet 191126



Part No: 646.9701

Job Qty: 4 pcs

Part Name: Cutter Sub Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/22/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG 646.9701 REV.F IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS IPP REV :B AS PER REV D 16-03-07
JLM VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		3/22/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		MAR 04 2019
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Plex 2/21/19 1:18 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐		DEPARTMENT/PROCESS <table style="width:100%;"><tr><td>Skid-tube ☐</td><td>Cross tube ☐</td><td>Eng. (Non-AW) ☐</td><td>Engineering ☐</td></tr><tr><td>Machining ☐</td><td>Small Fab ☐</td><td>Prod. Eng. Coord. ☐</td><td>Water Jet ☐</td></tr><tr><td>Large Fab ☐</td><td>Finishing ☐</td><td>Rec/Store/Packaging ☐</td><td>Supplier Quality ☐</td></tr></table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐														
Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐																														
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐																														
Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐																														
Date : _____		Sequence #: _____		MRB (QSI042)																													
Description Work Order Deviation Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-6200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S158519 Part: 646.9701 Job No: 191126 Serial No/Batch: S158519 Revision: G Inspector: Exp Date: Instructions: Date: 03/04/19																																	
Root Cause <table style="width:100%;"><tr><td>Operator ☐</td><td>Pressure, ☐</td></tr><tr><td>Manufacturing Process ☐</td><td>Bending ☐</td></tr><tr><td>Equip/Tooling ☐</td><td>Crushing ☐</td></tr><tr><td>Handling/Presservation ☐</td><td>Cracks ☐</td></tr><tr><td>Material ☐</td><td>Crimp/Kink/Ripple/Wave/Twist ☐</td></tr><tr><td>Product Improvement ☐</td><td>Marks/Chatter ☐</td></tr><tr><td>Process Improvement ☐</td><td>Mislabeled ☐</td></tr><tr><td>Human Factors ☐</td><td>Other/Details: _____</td></tr></table>		Operator ☐	Pressure, ☐	Manufacturing Process ☐	Bending ☐	Equip/Tooling ☐	Crushing ☐	Handling/Presservation ☐	Cracks ☐	Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Product Improvement ☐	Marks/Chatter ☐	Process Improvement ☐	Mislabeled ☐	Human Factors ☐	Other/Details: _____	<table style="width:100%;"><tr><td>☐ Broken/Damage/Defect</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Incomplete/Unclear Instructions</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Drill Holes</td><td>☐ Off-set/Set-up</td><td></td></tr><tr><td>☐ Fit/Function</td><td></td><td></td></tr></table>				☐ Broken/Damage/Defect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Incomplete/Unclear Instructions	☐ Out of Sequence	☐ Misread	☐ Drill Holes	☐ Off-set/Set-up		☐ Fit/Function		
Operator ☐	Pressure, ☐																																
Manufacturing Process ☐	Bending ☐																																
Equip/Tooling ☐	Crushing ☐																																
Handling/Presservation ☐	Cracks ☐																																
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐																																
Product Improvement ☐	Marks/Chatter ☐																																
Process Improvement ☐	Mislabeled ☐																																
Human Factors ☐	Other/Details: _____																																
☐ Broken/Damage/Defect	☐ Wrong Stock Pulled	☐ Part Lost/Missing																															
☐ Incomplete/Unclear Instructions	☐ Out of Sequence	☐ Misread																															
☐ Drill Holes	☐ Off-set/Set-up																																
☐ Fit/Function																																	

Plex 2/21/19 1:18 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	4 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21 8-88
				QC 21 - SA - 53	MAR 07 2019

Part Op 110 - (Pick Kit)
 Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE
 598: _____ exp. date: _____
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: _____) ****IDENTIFY AS PER IAW MPP-120***
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
646.9710 012	Body	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131228
646.9711 01	Blade	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5104600
MS21042L08	Nut	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	5080644
MS27039-08-19	Screw	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	5104359
NAS1149FN832P	Washer	48 Ea (12 ea)	110-Packaging 1 - Pick Kit	5143716

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.9710	4	10	0
	646.9711	8	31	0
	MS21042L08	24	1,232	0
	MS27039-08-19	24	773	0
	NAS1149FN832P	48	2,958	0

Part Specifications	
Specifications could not be found.	

Plex 2/21/19 1:18 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					